Work Order Monday, April 18,							٠ -				Page 1
Revision ID: Item Name: Pe		tart Qty: 6.00 keq'd Qty, 6.00		Accept	Cust Item II	,		S.	etup Start	· · · · · -	
	Process Plan:	·. K	Date://U+/8	Tooling: SPC (Y/N):	Da			Ŗ	un Start Stop		
Sequence ID/ Work Center ID		peration escription	·	Set Up/ Run Hours	Tool ID			Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D3204	Revision Rev A1		; •	0.00			·				,
Bandsaw Jeaspa Bandsaw 110 HAAS 1 HAAS CNC vertical magnetic statements of the second		AAS CNC VERTICA Memo 1- Machine	2.000" x 0.375" x 3.100" lon L MACHINING #1 e as per Folio FA357 and Dw	0.00 B.	•	10		10	8 .		
120 QC Quality Control	Q	9 C2- Inspect parts off i Memo	machine FAI/FAIB	0.00	B.A 11/05/	12		10	_ \$		

	-								
W/O:		- .	W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
_									
		·							
Part No	:	PAR #:	Fault Cat	tegory:	_ NCR: Yes	No DQ	A :	_ Date: _	
	R	esolution:	Disposit	on:	_ QA: N/C CI	osed:		Date: _	·
NCR:		1	WORK OR	DER NON-CONFORMA	ANCE (NCF	R)			
DATE	STED Description of NC		Corrective Action Section B			Verific	ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	k Secti		Chief Eng	QC Inspector
						,			
							1 1/2	ĺ	

Work	Order	ID	68573
Monday	Anril 18	2011	11-33-10



Page 2

Monday, April	18, 2011 11:.	33:19 AM			## MILIT ##### 1194 ###!							^ ··· D - · -
Item ID: Revision ID:	D3204-9			Accept					Setup	Start		
Item Name:	Pedal	-								Stop		
Start Date: Required Date:	4/18/2011 : 4/21/2011	Start Qty: 6.00 Req'd Qty: 6.00			Cust Item Customer:							
Reference:							_		Run	Start		
Approvals:	Process Pla	an:	Date:	Tooling:	D	Date:			1tun			
	QC:		Date:	SPC (Y/N):	D	Pate:				Stop		
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Rej		Reject Number	Insp. Stamp
130		QC8- Inspect parts - seco	ond check	مر 0.00	11/05/16			(0)				
QC Quality Control		Memo		0.00			(
140		Identify as per dwg & St	ock Location:	0.00					1-	-/.	0 /	1(10)
Packaging Packaging		Memo *****STOC	CK IN LARGE FAB****	0.00					11/1	/16		(107
		Ne			•							
150		QC21-Final Inspection	- Work Order Release	0.00							11/5	1184
QC		/ Memo		0.00				-				

V11-05-18

Quality Control

W/O:	<u> </u>		WO	RK ORDER CHAN	GES				
DATE	STEP	PR	OCEDURE CHAN		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							-		P
		· · · · · · · · · · · · · · · · · · ·							
Part No		PAR #:							
	Res	solution:	Disposition	ı:	QA: N/C	Closed: _		Date: _	
NCR:			WORK ORDE	R NON-CONFORM	MANCE (NC	R)			
DATE	STEP	Description of NC			ection B		Verification A		Approval
	012.	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat	e Se	ction C	Chief Eng	QC Inspector
		,							
_						_			

Picklist Print

Monday, April 18, 2011 11:33:26 AM

Work Order ID: 68573

Parent Item:

D3204-9

Parent Item Name: Pedal



Start Date: 4/18/2011

Required Date: 4/21/2011

Page 1

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP:

□C□05.08.11□Added Step 25□ KJ/JLM□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0 375X02 00		Durchased	No			100	f	20 3800	0.2688	1.60768/	1		

6061-T6 Bar .375 x 2.00

Location MAT001

MAT002

19059

Loc Qty 18.58

> 18.58 1.8

> > 1.8

Loc Code

	-							
W/O:		7.7	V	ORK ORDER CHANGI	ES			
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date Qt	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							-	
						,		

		·				-		
Part No	*	PAR #:	Fault Ca	tegory:	NCR: Yes	No DQA:	Date: _	***************************************
	R	esolution:	Disposit	ion:	QA: N/C Cld	osed:	Date: _	
NCR:		V	VORK OR	DER NON-CONFORMA	NCE (NCR)		
DATE	STEP	Description of NC		Corrective Action Section		Verificatio	n Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
٠,								
				•				
<u></u>						· ·		
					ı			
٠								
	1)	1			i		

DART AEROSPACE LTD	Work Order:	18573
Description: Pedal	Part Number:	D3204-9
Inspection Dwg: D3204 Rev: A1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
+/-0.030	0.505	1			
+/-0.010	0.249	7			
+/-0.010	0.081	~			
+/-0.010	0.1001450	~			
+/-0.010	0.610				
+/-0.010	3.003	/			
+/-0.030	1,999	~			
+0.010/-0.000	0.312	/			
+/-0.010	0,783	/			
+/-0.010	1.750	/			
+0.005/-0.000	40.138	✓			

	+/-0.030 +/-0.010 +/-0.010 +/-0.010 +/-0.010 +/-0.030 +0.010/-0.000 +/-0.010 +/-0.010	Tolerance Dimension +/-0.030	Tolerance Dimension Accept +/-0.030	Tolerance Dimension Accept Reject +/-0.030	Tolerance Dimension Accept Reject Inspection +/-0.030

Measured by:	S.A	Audited by:		Prototype Approval:	N/A
Date:	11/05/12	Date:	11/6 16</th <th>Date:</th> <th>N/A</th>	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	05.02.17	New Issue	KJ/JLM , ,	1
В	06.03.21	Dwg Rev update	KJ/JLM ox	Chil
			· (1	

W/O:	_		W	ORK ORDER CHANG	EŜ				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:	Fault Cate		NCR: Ves	No DO	Δ.	Date:	
raitino		esolution:							
NCR:		1	WORK ORD	ER NON-CONFORMA	NCE (NCR)		_	
DATE	STEP	Description of NC	Corrective Action Section B				cation	Approval	Approval
DAIL	JILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Sect	tion C	Chief Eng	QC Inspector
1	1	I .			1	1			1

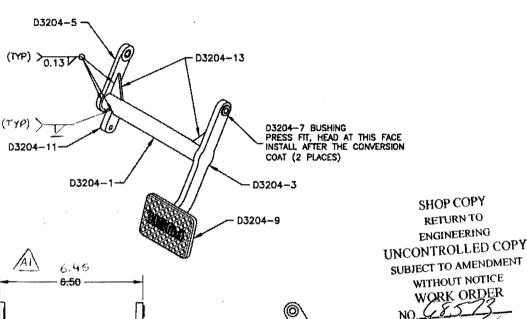
[&]quot;H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE



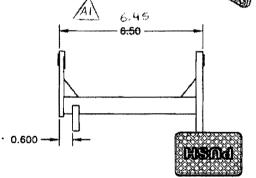


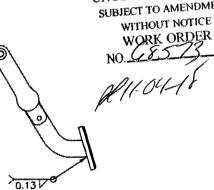
DESIGN 片	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA				
CHECKED,	APPROVED	DRAWING NO.	REV. A			
-4		D3204	SHEET 1 OF 3			
DATE		TITLE	SCALE			
04.01.27		RELEASE PEDAL ASSEMBLY	NTS			
 Α ,,	04.01.27	NEW ISSUE				

6.45 WAS 6.50



05.07.15





D3204-041 RELEASE PEDAL ASSEMBLY

- BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020 ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010 WELD ASSEMBLY PER QSI 004

- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 9) POWDER COAT ASSEMBLY GREY SANDTEX (REF. 4.3.5.6) PER QSI 005 4.3
 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 11) ALL DIMENSIONS ARE INCHES

Copyright @ 2004 by DART AEROSPACE LTD

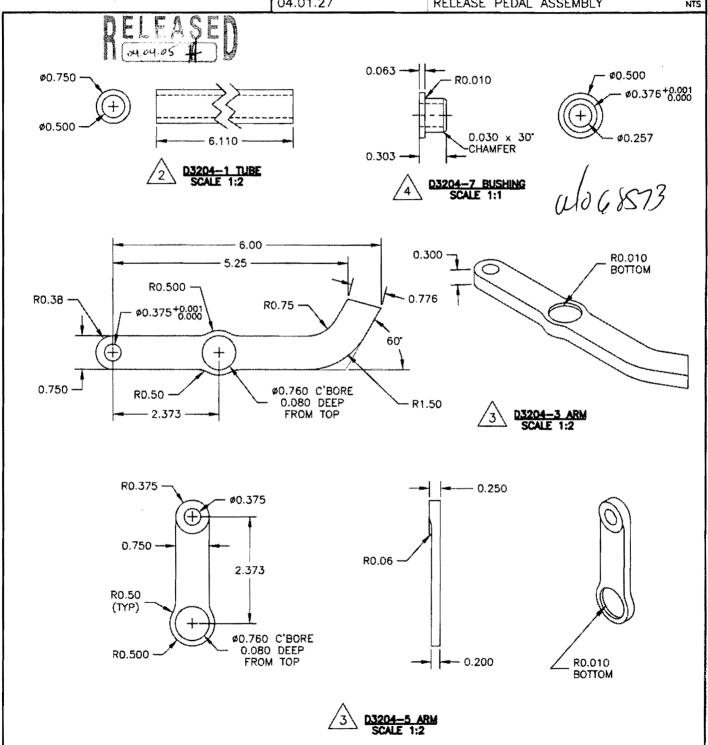
	-									
W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
		*								
Part No		PAR #:	Fault Cat	legory:	_ NCR: Yes	No DQ	A:	Date: _		
	R	esolution:	olution: Disposition: Q				QA: N/C Closed: Date: _			
NCR:		V	VORK ORI	DER NON-CONFORMA	NCE (NC	₹)		_		
DATE	STEP	Section A	Corrective Action Section B				cation	Approval	Approval	
DAIL			Initial Chief Eng	Action Description Chief Eng	Sign a		ion C	Chief Eng	QC Inspector	

^{&#}x27;H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE





DESIGN DRAWN BY		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA						
CHECKED &	APPROVED	DRAWING NO.	REV. A					
4	1 4	D3204	SHEET 2 OF 3					
DATE		TITLE	SCALE					
04.01.27		RELEASE PEDAL ASSEMBLY	NTS					



Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

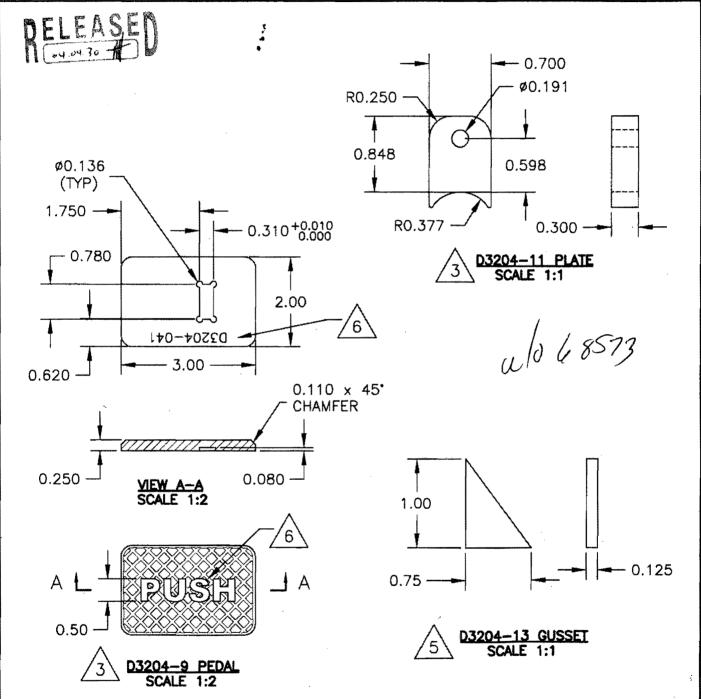
W/O:			W	ORK ORDER CHAN	IGES							
DATE	STEP	PROCEDURE CHANGE					Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
		·										
Ÿ										·		
Part No		PAR #:	Fault Ca	Fault Category: NC			CR: Yes No DQA: Date:					
	R	esolution:	Disposit	QA:	A: N/C Closed: Date:				<u>.</u>			
NCR:		WORK ORDER NON-CONFORMANCE (NCR)										
DATE	STEP	Description of NC		Corrective Action Section B			Verification		Approval	Approval		
DALL		Section A	Initial Chief Eng	Action Descriptio Chief Eng	n ,	Sign & Date			Chief Eng	QC Inspector		
				ja P								
				_								
	,											
					e.							

^{*}H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE





DESIGN PA	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CAN	
CHECKED,	APPROVED	DRAWING NO.	REV. A
4	-	D3204	SHEET 3 OF 3
DATE		TIME.	SCALE
04.01.27		RELEASE PEDAL ASSEMBLY	NTS



Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

W/O:		WORK ORDER CHANGES									
DÁTE STEP			OCEDURE CHANGE			Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
									,		
			•								
Part No		PAR #:	PAR #: Pault Category NC			NCR: Yes No DQA: Date:					
, R		esolution: Disposition: QA			QA:	N/C Clos	sed:	Date:			
NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
	STEP	Description of NC	Corrective Action Section B				Verification	Approval	Approval		
DATE		SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section C	Chief Eng	QC Inspector	
		•	• .								
									2.		
				*		-					
		*	•	:					, ;		
					1						

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevE